

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003131**Date Inspected:** 25-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei/Li Yanhua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

**Bay 3 – Heavy Duty Machinery Shop**

The QA Inspector observed ZPMC qualified welder Dong Yi Qun ID 059450 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP025-001, and DP74-001.

The QA Inspector Dixon was informed by ZPMC QC Inspector Mr. Tao Lay that ZPMC CWI Inspector CWI Li Yanhua, and Sun Wei and ABF personnel were about to perform an R2 visual repair inspection on deck panel DP025-001 DP027-001, DP065-001, and DP074-001 requested that a Caltrans QA Inspector also performed a visual inspection on the deck panel.

After an agreement was reached by all parties for the repairs which needed to be made on the deck panel the QA Inspector identified the repairs to be completed as R2 inspections by marking the yellow tag which is pasted to the outside U-Ribs on the deck panel

The deck panel repair welding in the progress generally appeared to conform to contract specifications.

Bay # 1

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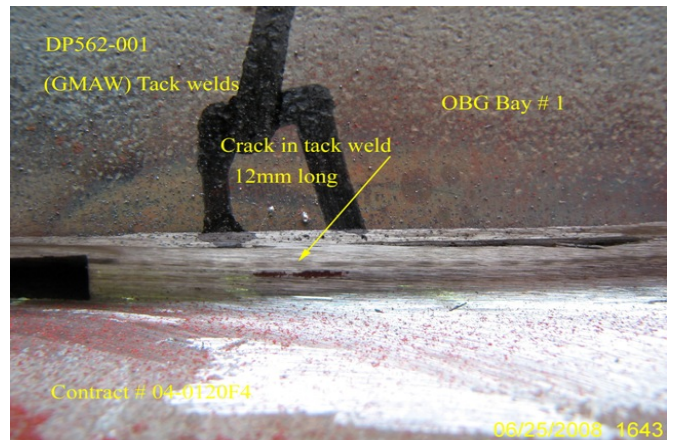
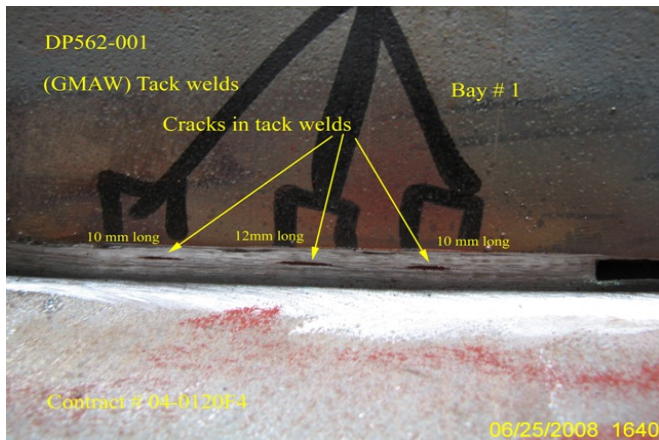
## WELDING INSPECTION REPORT

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The QA Inspector inspected deck panel tack welds on DP562-001 at Gantry # 1 and observed 42 cracked tack welds which ZPMC personnel had found during a Magnetic Particle Inspection and had marked the U-rib numbering each indication found. The QA Inspector verified the length of the indications. ABF personnel Wang Zhen Hua and Lv Yun were also present to verify the cracks in the tack welds.

For more detail see photographs shown below:



### Summary of Conversations:

As noted within the report shown above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dixon,Roscoe	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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